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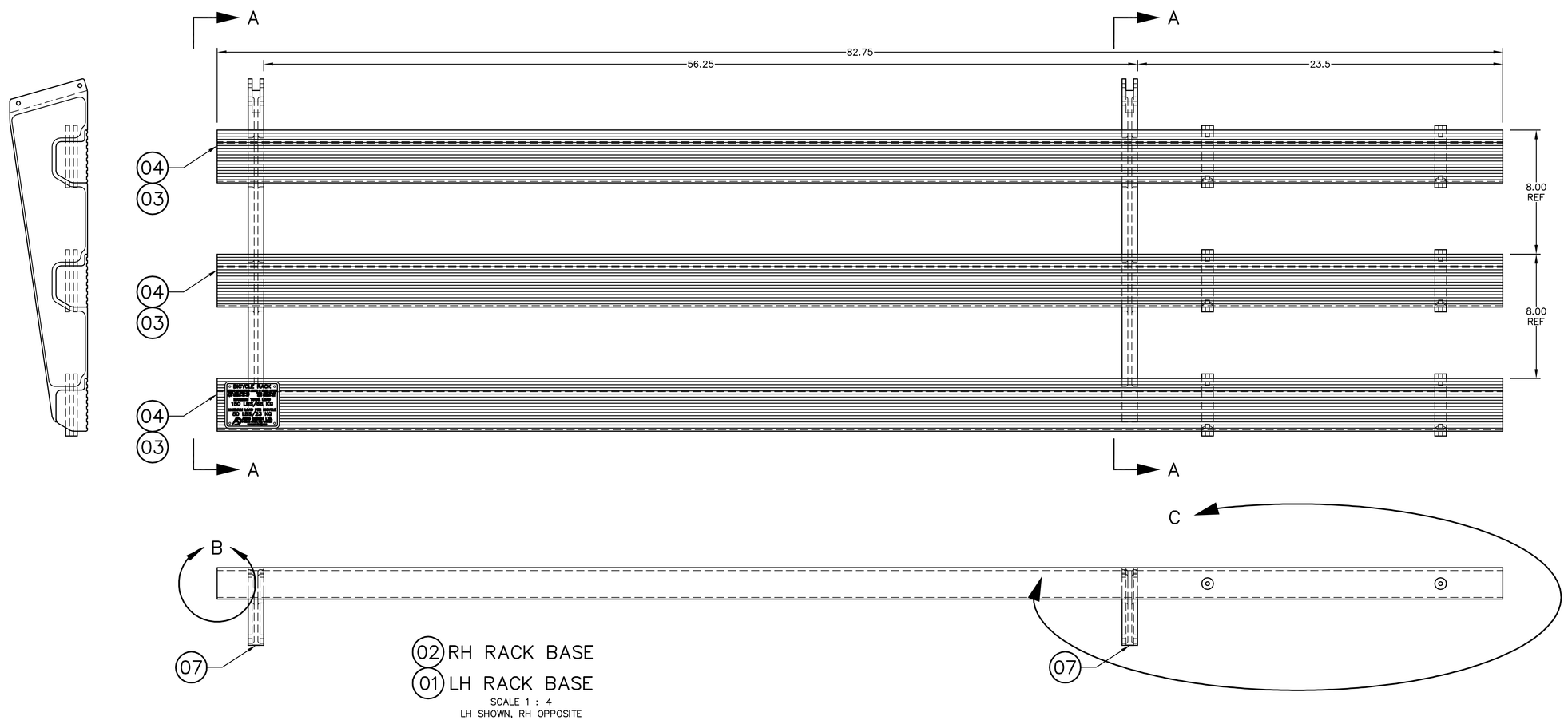
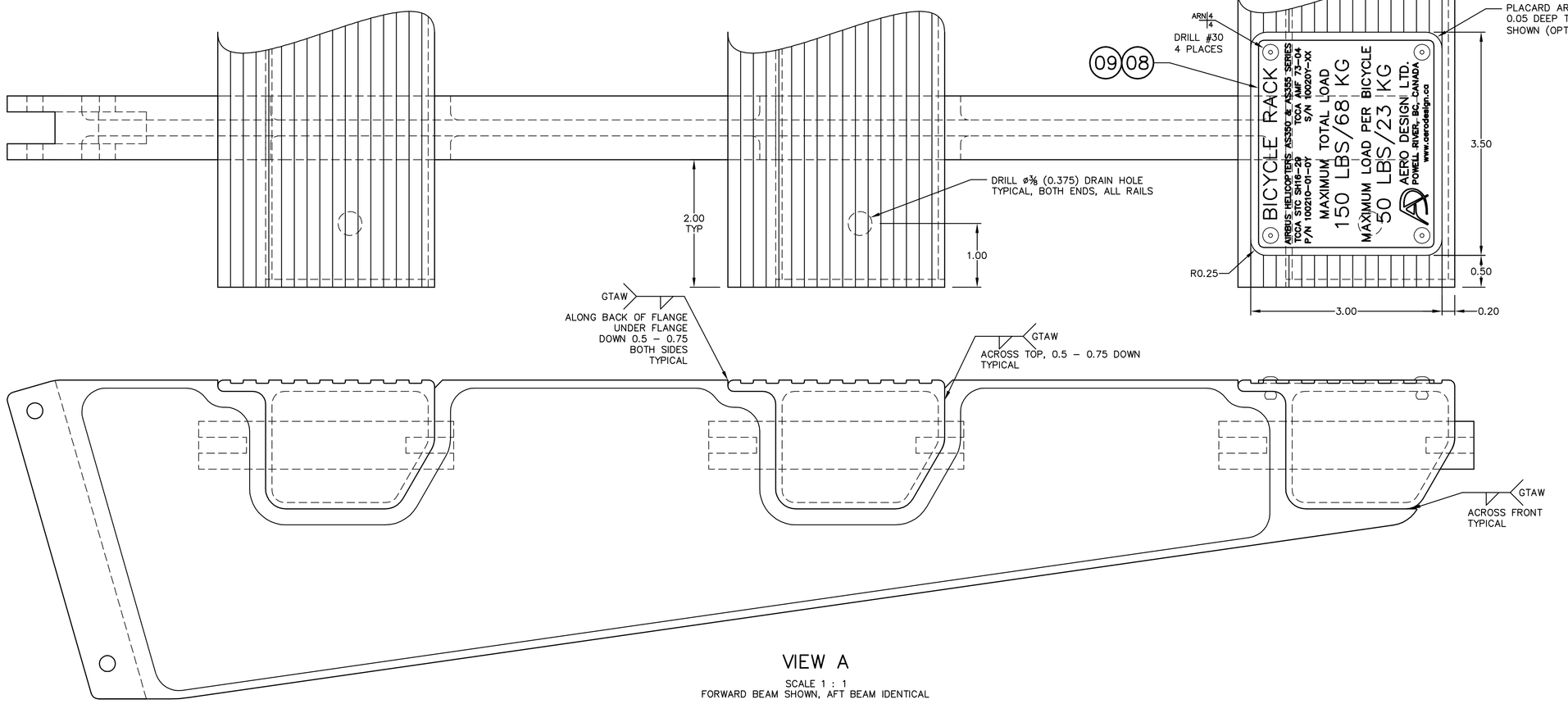
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



SCALE 1 : 4
LH SHOWN, RH OPPOSITE

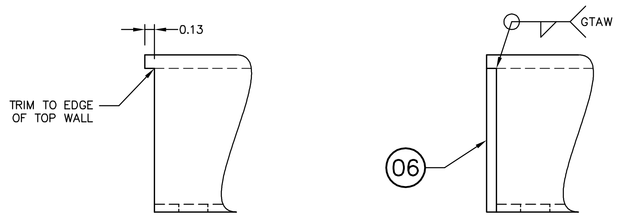
NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 60XX ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ANSI/AWS ER4043.
3. FINISH, ALUMINUM PARTS – AFTER WELDING:
   THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT.
   ALTERNATE, POWDER COATING:
   – THOROUGHLY DEGREASE USING TOP CHEMICALS TOP COAT 8888 DEGREASER / IRON PHOSPHATE @ 3% BY VOLUME.
   – POWDER COAT USING SHERWIN WILLIAMS POLYESTER SUPER DUTY POWDER OR EQUIVALENT POWDER COAT MATERIAL AND PROCESS THAT DOES NOT EXCEED TEMPERATURE/TIME LIMITS NOTED BELOW.
   – CURE POWDER COATING AT 392°F (±10°F) FOR 20 MINUTES (±3 MIN).
4. INSTALL PLACARD AFTER SURFACE FINISH IS DRY.



VIEW A

SCALE 1 : 1
FORWARD BEAM SHOWN, AFT BEAM IDENTICAL

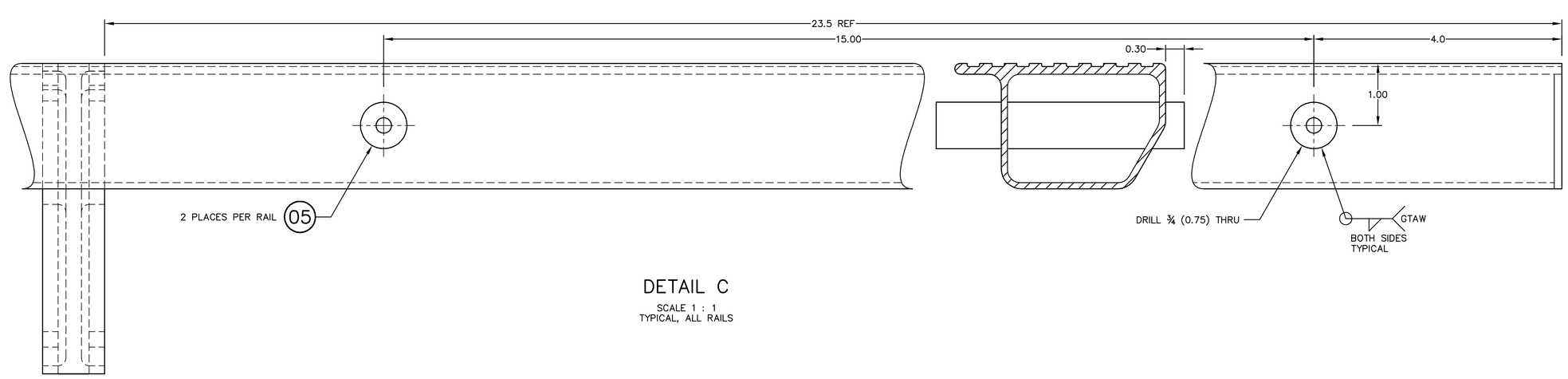


DETAIL B

SCALE 1 : 1
TYPICAL, ALL ENDS OF RAILS
BEFORE WELDING

DETAIL B

SCALE 1 : 1
TYPICAL, ALL ENDS OF RAILS



DETAIL C

SCALE 1 : 1
TYPICAL, ALL RAILS

		4	4	CR3213-4-04	10	BLIND RIVET	ALT: HR3213-4-04		
		1		100227-02	09	PLACARD			
			1	100227-01	08	PLACARD			
		2	2	100230-01	07	BEAM			
2	2			82720-04	06	CAP			
2	2			100226-01	05	RACK BUSHING			
		3		100215-04	04	RH RAIL			78230 EXTRUSION
			3	100215-03	03	LH RAIL			78230 EXTRUSION
				100215-01-02	02	RH RACK BASE			
				100215-01-01	01	LH RACK BASE			
04	03	02	01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY	QTY	QTY				LIST OF MATERIALS		

BASIC CODE REF. NAS 523

DASH NO. FOR DIAMETER
N=MFD. HEAD NEAR SIDE
F=MFD. HEAD FAR SIDE

C=COUNTERSUNK
D=DIMPLE
DIGIT=# OF SHEETS TO BE DIMPLED

DASH NO. FOR LENGTH

BASIC CODES:
BJ = MS20470AD
BB = MS20426AD
ARN = CR3213
ARM = CR3212

INSTALL NEW RIVET
REMOVE/REPLACE RIVET
EXISTING RIVET

APPROVALS		DATE
DRAWN:	JEFF CLARKE	13 JUNE 2016
CHECKED:	JASON REKVE	13 JUNE 2016

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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AIRBUS HELICOPTERS AS350 & AS355 SERIES
BICYCLE RACK INSTALLATION
RACK BASE FABRICATION

SCALE	DWG. SIZE	DWG. NO.	REV.
1 : 4	A0	100215	0
SHEET 1 OF 1			